

Date: Thursday, 10/25/2007 10:14:12 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BRACKET ASS'Y
Job Number : 35378	
Estimate Number : 12522	
P.O. Number : N/A	Part Number : D35311
This Issue : 10/25/2007 S.O. No. : NA	Drawing Number : D3531 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 34826	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 11/15/2007 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 07-09-24 EC verified by DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S040	6061-T6 .040 Sheet
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3.5748



Comment: Qty.: 0.3972 sf(s)/Unit Total : 3.1777 sf(s)
6061-T6 .040 Sheet
(M6061T6S040)
Batch: 105842 IB 07-10-31

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3531
Dwg Rev: A 07-10-31
Prog Rev: A

9

2-Deburr if necessary 07-10-31

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



07-10-31



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK 7/10/31

counted
x9

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
Bend as per Dwg D3531

8/3 07/11/02 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 8/11/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:14:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 35378

Part Number: D35311

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

counts
6 H1102 (9)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 07-10-04 (9)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

mf 07-11-05

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: *GA*

mf 07-11-05 (9)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/11/05

Job Completion



C207111105

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35378
Description: Bracket		Part Number:	D3531-1
Inspection Dwg: D3531 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.196	+0.005/-0.001	.197	X			
Ø0.129	+0.005/-0.001	.128	X			
0.33	+/-0.030	.33	✓			
2.840	+/-0.010	2.840	✓			
1.70	+/-0.030	1.70	X			
1.45	+/-0.030	1.45	X			
0.38	+/-0.030	.38	✓			
0.19	+/-0.030	.19	✓			
5.88	+/-0.030	5.88	X			
12.66	+/-0.030	12.66	X			
0.600	+/-0.010	.600	X			
1.77	+/-0.030	1.77	✓			
1.24	+/-0.030	1.24	X			
1.16	+/-0.030	1.16	✓			

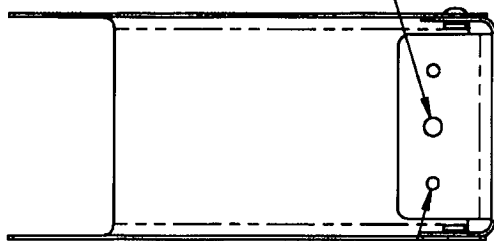
Measured by:	IB	Audited by:	S	Prototype Approval:	N/A
Date:	07-10-31	Date:	07/10/31	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.10.15	New Issue	KJ/EC/DD	IB



DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3531	REV. A SHEET 1 OF 3
DATE 07.06.19	TITLE BRACKET ASSEMBLY		SCALE 1:2
REV A	DATE 07.06.19	DESCRIPTION NEW ISSUE	

4
TRANSFER DRILL #9 ($\varnothing 0.196$)



TRANSFER DRILL #30 ($\varnothing 0.129$)
INSTALL MS20470AD4-4 RIVET
(2 PLACES)

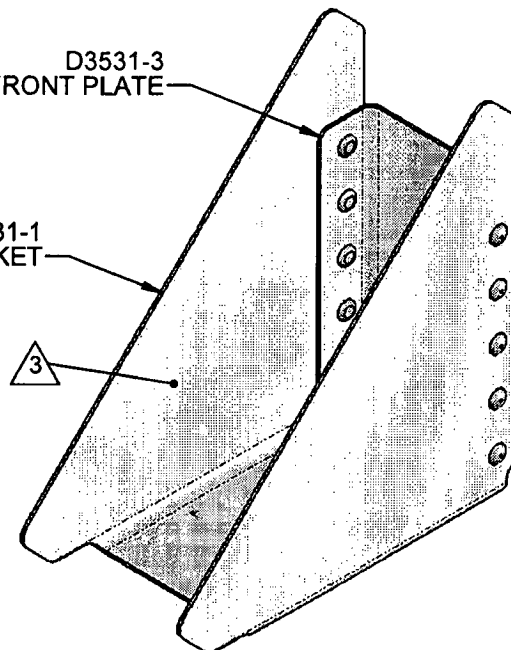
4

RELEASED
07.08.03

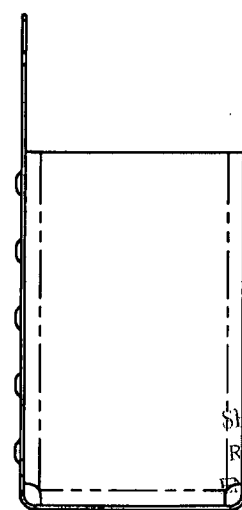
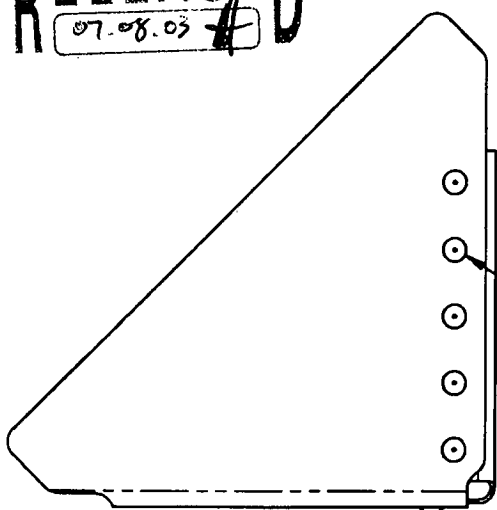
D3531-3
BRACKET FRONT PLATE

D3531-1
BRACKET

3



MS20470AD4-4
(10 PLACES)



D3531-041 BRACKET ASSEMBLY

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY BLACK
SANDTEX (4.3.5.7) PER DART QSI 005 4.3
ALL PARTS
- 2) ASSEMBLE PER DART QSI 003
- 3) IDENTIFY WITH DART P/N "D3531-041" USING
WHITE MARKER ON INSIDE OF BRACKET
ASSEMBLY, WHERE INDICATED
- 4) TRANSFER DRILL HOLES FROM D3531-1 BRACKET
THROUGH D3531-3 BRACKET FRONT PLATE
BEFORE FINISHING

PARTS LIST

QTY.	P/N	DESCRIPTION
X	D3531-041	BRACKET ASSEMBLY
1	D3531-1	BRACKET
1	D3531-3	BRACKET FRONT PLATE
12	MS20470AD4-4	RIVET

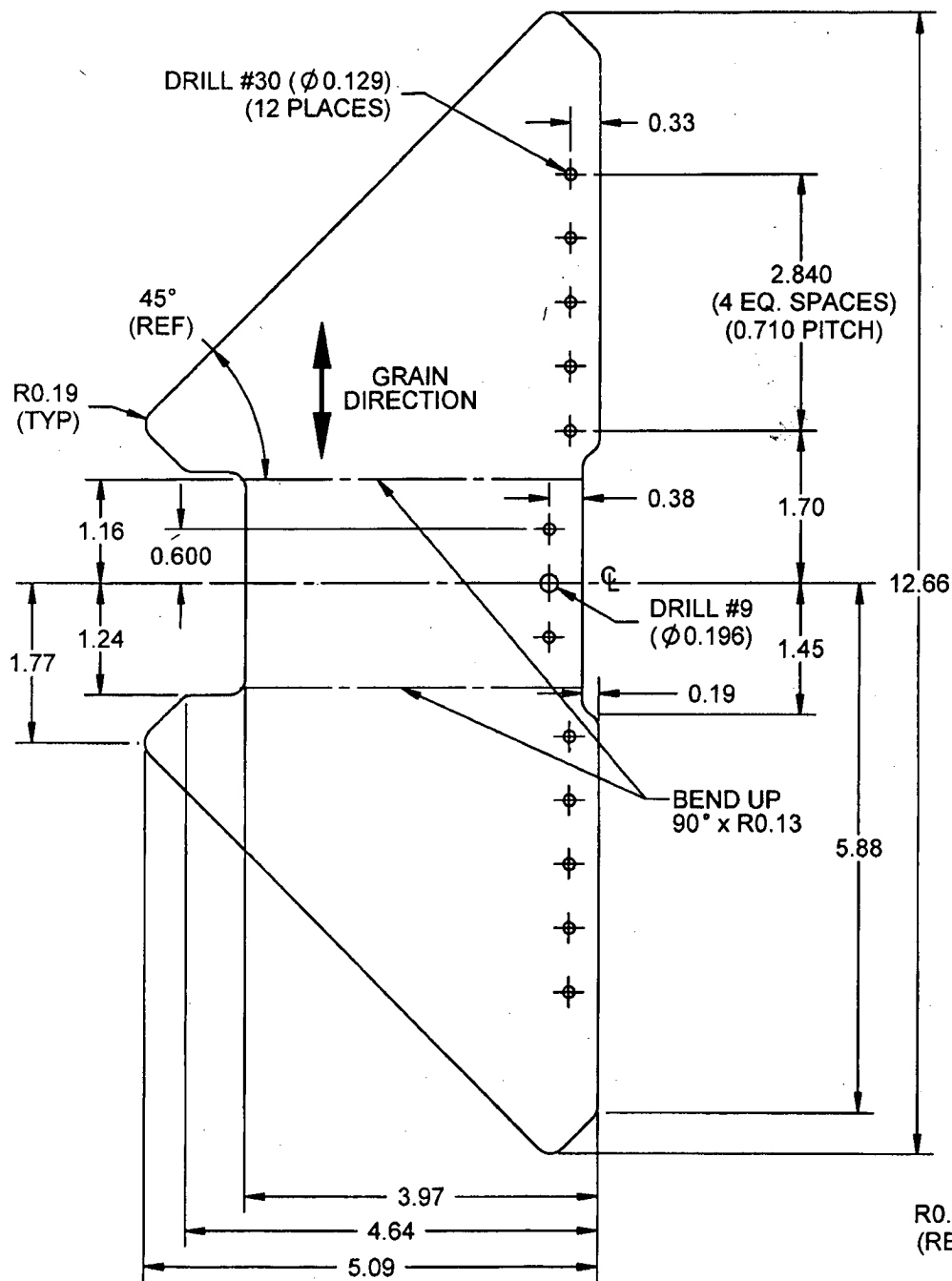
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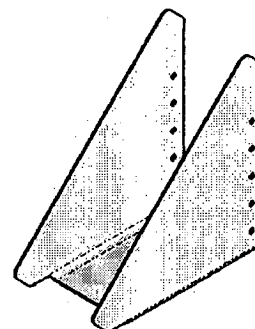
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CHECKED LE	APPROVED HA	DRAWING NO. D3531	REV. A SHEET 2 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2



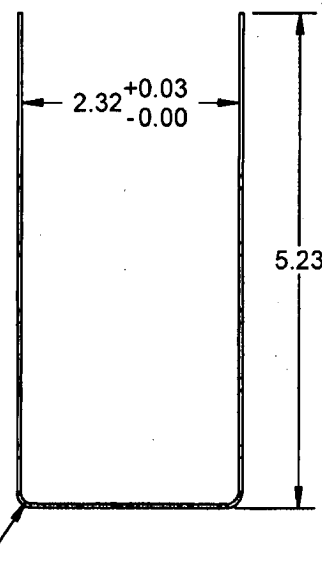
D3531-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ



RELEASED
07-08-03



D3531-1 BRACKET

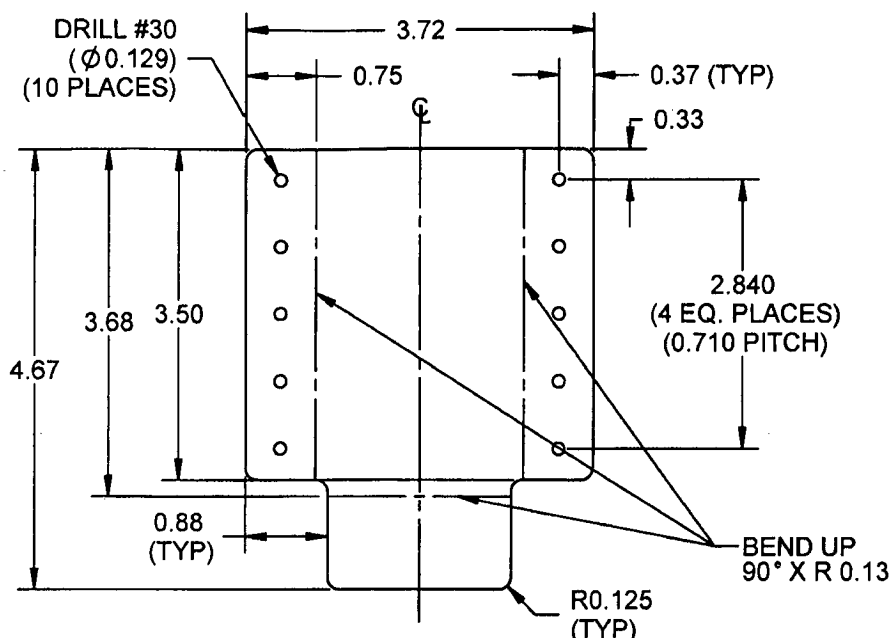
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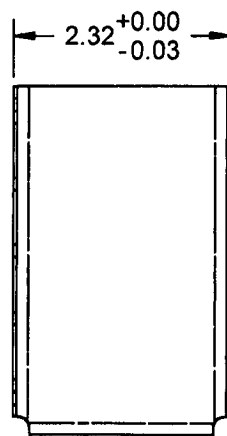
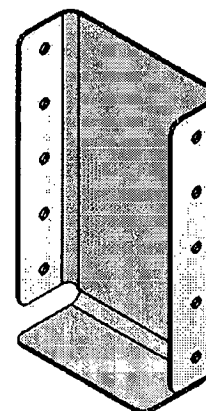


DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED #	DRAWING NO. D3531	REV. A SHEET 3 OF 3
DATE 07.06.19		TITLE BRACKET ASSEMBLY	SCALE 1:2

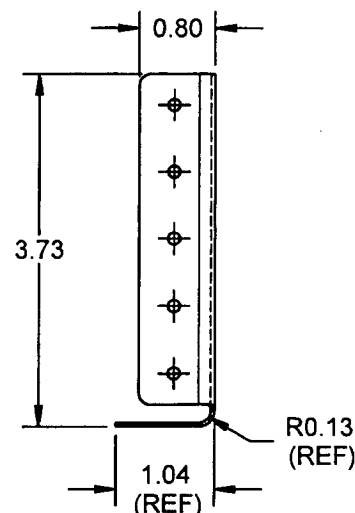


D3531-3F FLAT PATTERN

RELEASED
07.08.03 **#**



D3531-3 BRACKET FRONT PLATE



NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT ϕ

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